

Date: Wednesday, 19/07/2006 2:02:02 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET (A119) ARMS
Job Number	: 27983		
Estimate Number	: 12437		
P.O. Number	: <i>N/A</i>	Part Number	: D35181
This Issue	: 19/07/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3518 PRELIMINARY B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : R & D SM/MED FAB	Drawing Revision	: A PRELIMINARY
Previous Run	: 27696	Material	: <i>N/A</i>
Written By	: <i>See comment below</i>	Due Date	: 26/07/2006 Qty: 2 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: EST rev. A 05.06.06 preliminary EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6H0875	6061-T6 7/8" HexBar
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Comment: Qty.: 1.1070 f(s)/Unit Total: 2.2140 f(s)

6061-T6 HEX BAR 0.875

(M6061T6H0875)

Batch: *M101694*
[Signature] 06/07/31

2.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE
 DRILL & THREAD AS PER DRWG D3518

[Signature] 06/07/31

2

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 DRILL HOLES PER DRWG D3518
 DEBURR IF NECESSARY

[Signature] 06/07/31

2

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 06/07/31

2

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 06/07/31

2

Date: Wednesday, 19/07/2006 2:02:03 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET (A119) ARMS

Job Number: 27983

Part Number: D35181

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-08-01

(2)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-08-01

(2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

sl 06/08/02

(2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

sl 06/08/02

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

sl 06/08/03 (2)

Job Completion

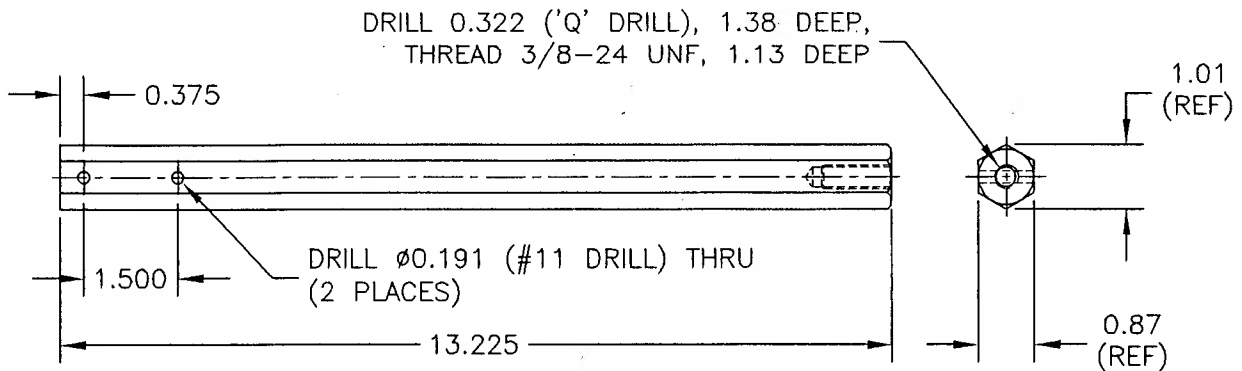


C 06/08/02

PRELIMINARY ISSUE

06.07.19

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3518	REV. B SHEET 2 OF 2
DATE 06.07.17		TITLE BASKET (A119) STRUT	SCALE 1:3



PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06.07.19

D3518-1 STRUT

NOTES:

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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